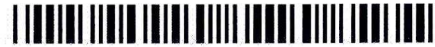




Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
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Tel (613) 632-5200
Fax 613 632-5246

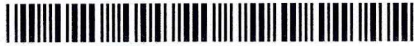
D3913-041
Job Sheet 195757



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	7/15/19		0.00	19.61	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
110	QC 9	1 pcs	7/15/19		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24	DAS 24	JUN 26 2019
							QC 9 - 43	9-89	
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	7/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	DAS	
							QC 5 - 24	24	JUN 26 2019
							QC 5 - 3	9-89	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S193854



Part: D3913 - 041

Job No: 195757

Serial No/Batch: S193854

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/19

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						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
125	Handfinish - 2-1 Pressure-B4B	1 pcs	7/15/19	0.00	0.29	Handfinish - 2 - 1 - B4B	
						Handfinish - 2 - 2 - B4B	
						Handfinish - 2 - 3 - B4B	BL 19-7-2
						Handfinish - 2 - 4 - B4B	
130	Powdercoat - 2 White B4B	1 pcs	7/15/19	0.00	0.93	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-7-2
						Powdercoat - 4 - B4B	
140	QC 3	1 pcs	7/15/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	BL 19-7-2
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
150	Handfinish - 4-1-Assembly-B4B	1 pcs	7/15/19	0.00	0.50	Handfinish - 4 - 1 - B4B	BL 19-7-2
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	

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DAS
15
9-89

				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160 QC 5	1 pcs	7/15/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
170 Packaging 3-1 - Stock - B4B	1 pcs	7/15/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	1	7/15/19	0.00 0.00	QC 21 - SA - 21	

DAS
40
9-89

JUL 02 2019

HL 19-7-2

DAS
21
9-89

JUL 02 2019

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op **100** - Weld per dwg A/R S.S. rod Batch: 136920 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect
 Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to
 fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913
 take lid to locate hinge and bracket 4- Weld D4672-1 blanking plates as per dwg
110 - QC9- Inspect visual per QSI004- Fusion Welds
120 - QC5- Inspect part completeness to step on W/O
125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
130 - White Gloss(Ref.4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder
 coat
140 - QC3- Inspect Part Finish
150 - Assemble as per dwg - Pick Kit
160 - QC5- Inspect part completeness to step on W/O
170 - Identify as per dwg & Stock Location: _____
180 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 188852
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 179518
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 184576
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 189078
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 179688
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 178219
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 188141
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S 182578
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	S 121276
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	S 173533
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 180771
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 186358
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	S 179504
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 181473
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	S 181719
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	S 184347
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	S 181090
AN3-10A	Bolt	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S 179612-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	F 86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S 155667
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	S 157462-1
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	S 155976
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S 188988
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	S 136362

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	52	2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190739	wa004-6	_____

D3913-1	1	9	1
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Allocated Container Detail

Qty	Container No	Location	Init
1	S190740	wa004-11	_____

D3913-15	1	24	1
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Allocated Container Detail

Qty	Container No	Location	Init
1	S190741	wa004-5	_____

D3913-3 1 9 1

Allocated Container Detail

Qty	Container No	Location	Init
1	S190742	wa004-11	_____

D3913-7 2 12 2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190743	wa004-5	_____

D3913-9 1 12 1

Allocated Container Detail

Qty	Container No	Location	Init
1	S190744	wa004-11	_____

D3916-041 2 11 2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190745	wa004-5	_____

D3916-5 3 8 3

Allocated Container Detail

Qty	Container No	Location	Init
3	S190746	wa004-5	_____

D4016-1 3 40 3

Allocated Container Detail

Qty	Container No	Location	Init
3	S190747	wa004-5	_____

D4017-7 3 52 3

Allocated Container Detail

Qty	Container No	Location	Init
3	S190748	wa004-6	_____

D4017-9 2 12 2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190749	wa004-5	_____

D4020-11 2 4 2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190750	wa006	_____

D4021-1 3 40 3

Allocated Container Detail

Qty	Container No	Location	Init
3	S190751	wa004-6	_____

D4034-041 1 2 1

Allocated Container Detail

Qty	Container No	Location	Init
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1	S181473	wa004-5	_____
D4034-043	1	2	1

Allocated Container Detail

Qty	Container No	Location	Init
1	S181719	wa004	_____
D4672-1	2	13	2

Allocated Container Detail

Qty	Container No	Location	Init
2	S190752	wa004-1	_____
M304EX0.75-16F	32	844	32

Allocated Container Detail

Qty	Container No	Location	Init
32	S190753	wa006	_____
AN3-10A	6	209	0
D2931	2	701	0
D4021-5	2	44	0
MS20600-AD4W3	2	342	0
MS21042L3	6	1,170	0
NAS1149F0332P	12	2,505	0
NAS1149FN832P	2	2,426	0

150-Handfinish - 4-1-Assembly-B4B

Part Specifications

Specifications could not be found.

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